

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004770**Date Inspected:** 12-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

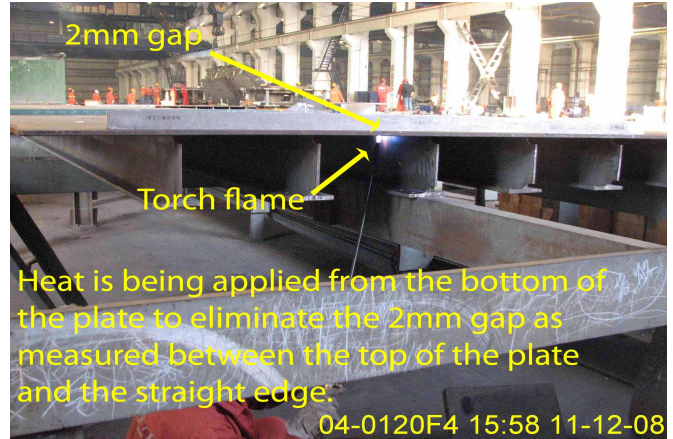
Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay 4

The Caltrans QA Inspector monitored ZPMC performing heat straightening of side plate SP765A in OBG Bay 4. Earlier in the day Caltrans personnel had observed this side plate was not flat. At around 1500 hours the QA Inspector observed ZPMC appears to have completed heat straightening of several sections of the side plate. The QA Inspector used a 1.5 meter long straight edge to gauge the flatness of one end of the side plate and a 2mm gap was observed under the center of the straight edge. The photograph below shows ZPMC heating the underside of the side plate to eliminate this gap. The QA Inspector observed ZPMC QC representative Mr. Huang Min was using a laser device to measure the temperatures of the areas that were being torch heated. Mr. Min showed the QA Inspector ZPMC heat straightening record #HSR1(B)-3625 dated 11-10-2008 that states SP765(A) had a maximum deformation of about 7mm, and that the plate will be heat straightened to eliminate this deformation. Below are photographs of ZPMC performing heat straightening of this side plate.

WELDING INSPECTION REPORT

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Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
